											DQA:	Dat	e:
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UPDA	NTE	QA Closed:	Dat	۰
			_		 -		_	<u> </u>					с.
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part f	•					Rework Scrap Use-as-is		ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	1	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR f	No.					Work Order Update	<u> </u>		~ 	Composite	Recysio	Supplier	
Root					Descri	ption of work order update		Initial	Action	n	Sign &		T
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descript	tion	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						,							
							AUL	T CATE	GORY				
Landi	ng G	iear Bending			Г	General Bend		Grain			Ovalized	ſ	Pressure/Forced
	П	Centre No	ot Concer	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	П	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	П	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Unc	lear	Part Lost/Mi	issing	Wrong Stock Pulled
	П	Cuffs				Contamination		Mainte	nance		Part Moved	_	_
		Heat Trea	it			Countersink		Mislabe	led	<u></u>	Positioned V	Vrong	
		Inspection	n Strip in	Tube		Cut Too Short		Misread	l	_	Power Loss/	Surge	Other
		Ripples in	Bend			Drill Hofes ·		Offset		<u></u>	•	_	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

Work Order ID 14.22:45 August-01-13 11:22:45 August-01-13 August-			*105	5297*		Page 2
Item ID: D3864-1 Revision ID: Item Name: Bushing		,	Accept	*N9000401	Setup Start Stop	*NS1* *NS2*
Start Date: 8/01/13 Required Date: 8/01/13 Reference:	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item ID: Customer:		
Approvals: Process QC:		te:	Tooling: SPC (Y/N):	Date:	Run Start Stop	"NRT"
Sequence ID/ Work Center ID 130 *120* Packaging Packaging	Operation Description Identify as per dwg & Stock Lo	cation: 5706 8	Set Up/ Run Hours 0.00	Tool ID Tool # P		Reject Insp. Number Stamp
*140 *140* QC Quality Control	QC21- Final Inspection - Work	Order Release	0.00		<u>MCJ 13</u>	513-08-06

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											DQA:	υa	œ.	
NCR: Y	es / No	o			WORK ORDER NON-	CON	FORM	MANCE / UP	DATE	ΩΔΙ	Closed:	 Da	to:	
					DISPOSITION	Т			AGAINST DI			 		. <u></u>
Work Orde	er:				DISPOSITION	_			AGAINSI DI	- -	IVIEIVI,	/ PROCESS		
Part N					Rework Scrap Use-as-is		therm	Skid-tube Machining noforming	Crosstube Small Fab Finishing	R		Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR N	lo		•		Work Order Update	┚╽		Large Fab	Composite	j		Supplier		
Root			T	Descri	lption of work order update	In	itial	Acti	ion	Si	gn &			
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Descri	iption		ate	Verificatio	n_	QC Inspector
Doc/Data														-
Equip/Tooling														
Operator						1								
Material [ļ						i	
Setup							3						ļ	
Other				1										
Process		- [i							
Supplier	7												i	
Training			}										ļ	
Unapproved						1							,	
					F	AULT	CATE	GORY						
Landir	ng Gear				General			-		_				
[Bendir	g			Bend		Grain			Oval	ized			Pressure/Forced
ĺ	Centre	Not Conce	ntric to	o/s	BOM/Route	ŀ	Hardwa	re		Over	/Under	tolerance		Temperature/Cure
	Cracks				Broken/Damaged	∐'	nspecti	on incomplete		Part	Incorre	ct		Weld
[Crushe	d/Crimped			Burrs	[]	nstructi	ions incomplete/U	Inclear	Part	Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part	Moved	·		-
	Heat T	reat			Countersink		Mislabe	led		Posit	ioned V	Vrong		
	Inspec	tion Strip ir	1 Tube		Cut Too Short	\prod_{i}	Misread			Pow	er Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

NCR: Y	res / No				WORK ORDER NON-	CON	IFORN	MANCE / UPI	DATE				
										QA Closed:	Da	te:	
Work Orde	 er:				DISPOSITION				AGAINST DI	EPARTMENT,	/PROCESS		
Part N					Rework Scrap		ſ	Skid-tube Machining	Crosstube Small Fab	-	Water Jet	Qualit	γ
NCR N	No		. <u>-</u>		Use-as-is Work Order Update	<u> </u>		noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier		
Root		T		Descri	ption of work order update	li	nitial	Act	ion	Sign &			
Cause	Date	∙Step	Qty	(or Non-conformance	Chi	ief Eng	Descr	iption	Date	Verificatio	n QC Inspe	ctor
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Process						1							
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Training													
Unapproved		<u> </u>	<u> </u>	<u> </u>			- 64 - 56	SORY		1			
				_	.	AUL	T CATE	JORY					
Landi	ng Gear				General	\Box	Cusin		1	Ovalized		Pressure/Ford	اسما
	Bending			., <u> </u>	Bend	\mathbf{H}	Grain		}-	_	.	⊢	
	⊢ ––	lot Conce	ntric to	^{5/5}	BOM/Route	-	Hardwa		}-	Over/Under		Temperature/ Weld	cure
	Cracks	(a : 1			Broken/Damaged	\vdash		on Incomplete		Part Incorred		├	المسالين
1	⊢ ⊣	/Crimped		<u> </u>	Burrs	-		ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock i	zunea
	Cuffs	_*		 	Contamination	\vdash	Mainte		 	Part Moved	Vena		
	Heat Tre		T. L.	-	Countersink	\vdash	Mislabe		 -	Positioned V	-	Othor	
	—	on Strip in	iupe	-	Cut Too Short	\vdash	Misread	i .	L	_rower Loss/	ourge	Other	.
	Ripples		~ .	_	Drill Holes	\vdash	Offset	-libration					
	i ilorque\	Naves in I	EXTRUSIO	n I	Drawing		OTO JUUI	Calibration					

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	105797
Description: Bushing	Part Number:	D3864-1
Inspection Dwg: D3864 Rev: A		Page 1 of 1

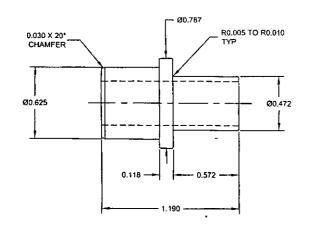
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+/-0.010	-624	V		Mic	PHO-02
Ø0.472	+/-0.010	1471	1		٠,	**
Ø0.386	+0.006/-0.001	. 385	-		PIN G	REF
0.572	+/-0.010	.574	/		Mic	(40-09
0.118	+/-0.010	, 114			VERY	P40-01
1.190	+/-0.010	1 188	V		II.	۸.
Ø0.787	+0.010/-0.001	1 188			f.	11
R0.005 to R0.010	N/A	_ 608			Rad 6	REF
	045					

	V/ 3				
Measured by:	40 /	Audited by:	PP	Preliminary Approval:	
Date:	13/08/02	Date:	13. f. Z	Date:	

Rev	Date	Change	Revised by	Approved
Α	09.05.20	New Issue	KJ , N	
В	10.12.21	Tolerances revised	KJ +	- 10

				
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105297 MLJ 13-08-01

D3864-1 BUSHING

NOTES: 1) MATERIAL: AISI 303 ROUND BAR 1) MATERIAL: AISI 303 ROUND BAR
(DART SPEC M303RX.XXX)
2) FINISH: NONE
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.05 LBS

A NEV	/ ISSUE		PH	08.12.04			
REV.		DESCRIPTION	BY	DATE			
DESIGN DRAWN	PH		DART AEROSPACE USA, INC				
CHECKED	1	DRAWING NO.		REV. A			
MFG. APPR.	Sillo	D3864 SHEET 1 0					
APPROVED	140	TITLE		SCALE			
DE APPR.	74	BUSHING		NTS			
DATE 08	.12.04	COPYRIGHT © 100 BY DART AEROSPACE USA, INC. THIS DOCUMENT OF THIS MAY DOCUMENT OF AEROSPACE USA, INC. HOT TO BE USED FOR MY REPORTED COMEDIC GRANIFICATION OF AEROSPACE OF A THIS MY DIVERS PERSON WITHOUT THIS PERSON COMPANIES OF A THIS MY DIVERS PERSON WITHOUT ARRANGED THE MAY DAY DESCRIPTION OF A PROPERTY OF A THIS MY DIVERS ARE ARRANGED THE MY DESCRIPTION OF A PROPERTY OF A THIS MY DIVERS ARE ARRANGED THE MY DIVERS ARE ARRANGED THE MY DIVERSION OF A PROPERTY OF A THIS MY DIVERS ARE ARRANGED THE MY DIVERSION OF A THIS MY DIVERS ARE ARRANGED THE MY DIVERS ARE ARRANGED TO A THIS MY DIVER					

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